

Date: Monday, 2/11/2008 2:15:01 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FUEL PURGE CANISTER	
Job Number	37369A		Part Number	D3262041	
Estimate Number	10440		Drawing Number	D3262 REV C	
P.O. Number			Project Number	N/A	
This Issue	2/11/2008	S.O. No. :	Drawing Revision	C	
Prsht Rev.	NC		Material	:	
First Issue	/ /	Type :	Due Date	2/28/2008	Qty: 5 Um: Each
Previous Run	36777				
Written By					
Checked & Approved By	PJM 02/11				
Comment	Est. C 05.03.10, Removed P/O for liquid penetrant inspection K JJLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	37369A	FUEL PURGE CANISTER
	Comment: Sub-Component FUEL PURGE CANISTER D3262-1 B 36777A (SP) BE 08/03/18	
2.0	37369B	FUEL PURGE CANISTER
	Comment: Sub-Component FUEL PURGE CANISTER D3262-3 B 37369B (GP) * 29937B (PR) BE 08/03/18	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings	
	Pick: Qty Part Number Description Batch A/R Aluminum Rod m106702 BE 08/03/18	
4.0	DO NOT USE	WELD INSPECTION
	Comment: WELD INSPECTION Pressure test as per Dwg D3262	QC#9 08-03-19 (S)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	JJ 08-03-24 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:15:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 37369

Part Number: D3262041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M107005



5X

Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

Mh 08/03/24

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 08-03-24

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 157

AS 08/03/25

(X5)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



h 08-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

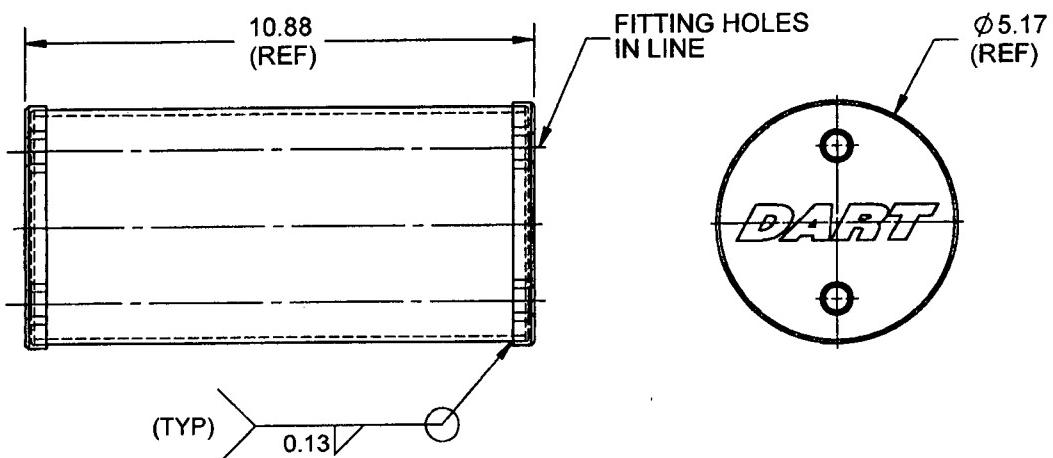
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3262
DATE 06.08.31		REV. C SHEET 1 OF 2
		TITLE FUEL PURGE CANISTER
SCALE 1:4		
REV	DATE	DESCRIPTION
A	04.05.06	FIRST ISSUE
B	05.02.14	ADD PRESSURE TESTING OPTION
C	06.08.31	Ø 5.165 WAS Ø 5.190

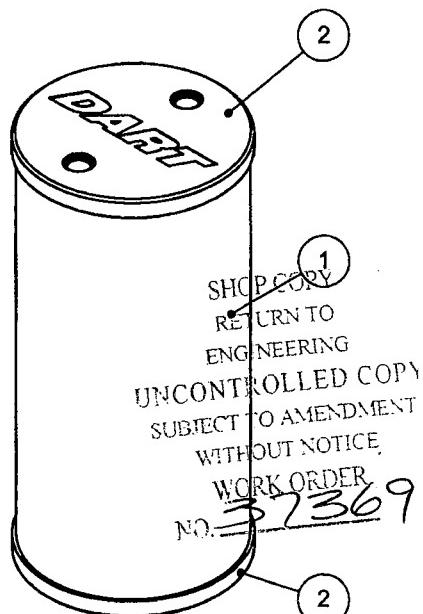
RELEASED

06.09.19 *H***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

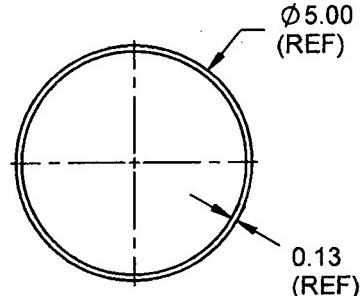
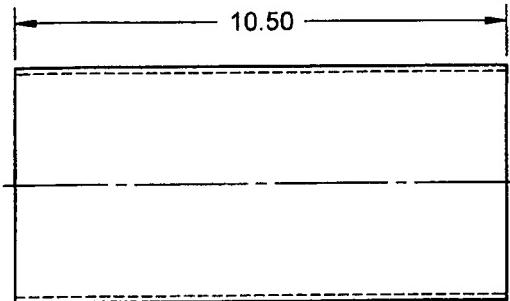
NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO **B**
CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



DART

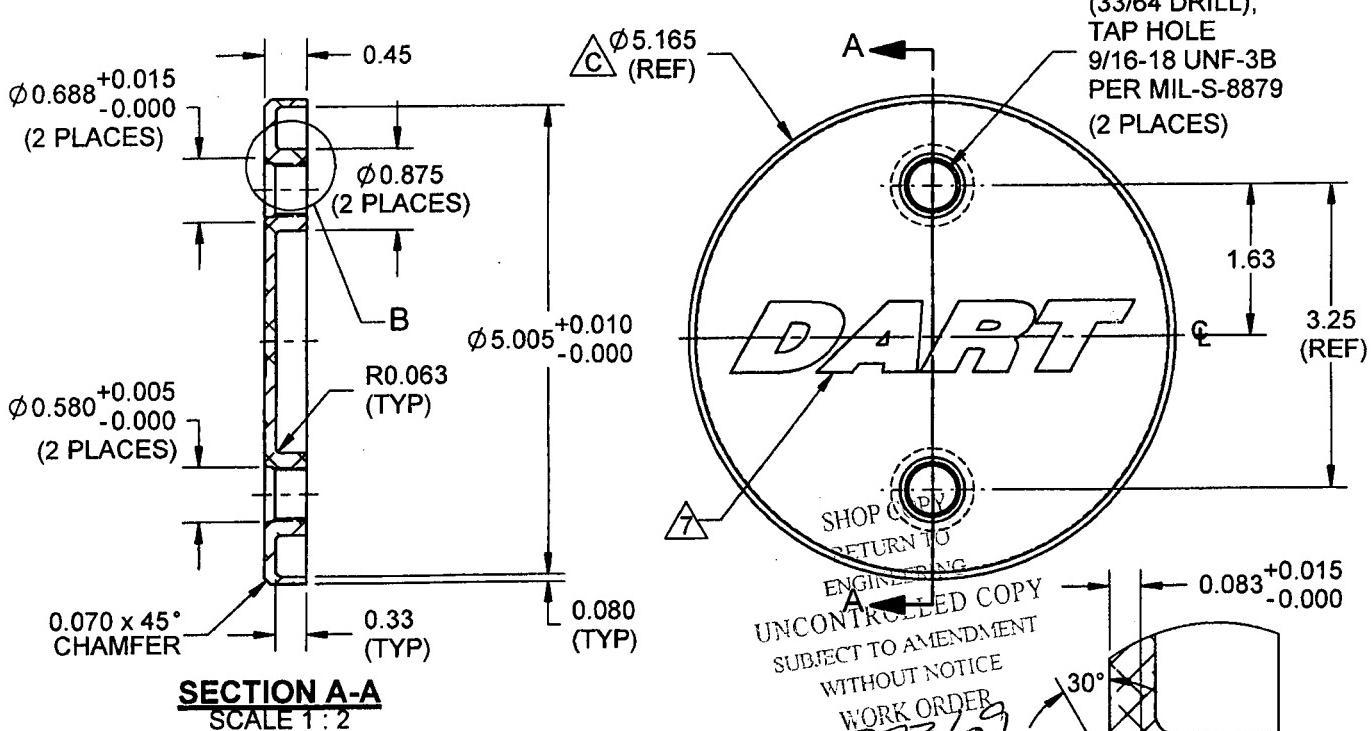
DESIGN <i>PF</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER	SCALE 1:4	



RELEASED
OC.09-19

D3262-1 TUBE

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)

**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)